



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

648.3545

Job Sheet 215414



Part No: 648.3545

Job Qty: 80 pcs

Part Name: Girt Base Strip



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/20

Job Tracking No:

Due Date: 11/18/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 648.3500 REV C IPP REV:A 20.11.13 NEW ISSUE FK VERIFY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	80 pcs		11/16/20	0.17	8.00	Waterjet - Omax		on 20/11/16
					2.5	hr	Waterjet - Omax - SCH-S		
110	QC 2	80 pcs		11/16/20	0.00	0.00	QC 2 - 1		on 20/11/16
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
112	Small Fab - 2 - B4B	80 pcs	11/17/20	0.00 8.00	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	DAS 21 9-89
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
					Small Fab - SCH-B	
114	QC 5	80 pcs	11/17/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS 82 9-89
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	NOV 17 2020
					QC 5 - SCH-B	
120	NV5000 - 1 - B4B	80 pcs	11/17/20	1.00 8.00	NV5000 - 1 - B4B	
					NV5000 - 2 - B4B	
130	QC 2	80 pcs	11/17/20	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	

NIA

MAT'L
MILL
TEST
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20/11/17

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20/11/17

					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
140	QC 8	80 pcs	11/17/20	0.00 0.00	QC 8 - 12	mk 20/11/27
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
142	Small Fab - 2 - B4B	80 pcs	11/18/20	0.00 8.00	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	

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				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
160 QC 21 - SA	80 pcs	11/18/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op **100** - 1-Cut as per DWG. DWG. Rev: C PROG. Rev: C 2-Deburr if necessary

Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB

112 - Mill holes chmfs as per DWG

120 - 1-Machine as per folio FD412 FOLIO REV: AA DWG REV: C 2-Deburr **CRITICAL REQUIREMENT TO DEBURR AND REMOVE SHARP EDGES**

130 - QC2- Inspect parts off machine FAI/FAIB

140 - QC8- Inspect parts - second check

142 - 1-Score surface, before applying primer, using 40 GRIT sand paper. 2-Primer finish: PC 4426, Vendor: Royal Adhesives & Sealants. S/N: 306820 -exp: 9/22/2021

150 - Identify as per dwg & Stock Location:

160 - QC21- Final Inspection - Work Order Release

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GA-
TBD

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M301S11GA-H50	301 SS Sheet - 1/2 hard 0.125	1.1200 sf (.014 ea)	100-Waterjet - Omax - 1	<u>5302475</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M301S11GA-H50	1	10	0

Part Specifications
Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐						
Date :	Sequence #:	QTY Affected :		MRB (QSI042)				
Description Work Order Deviation		Disposition			Completed By			
					Lead hand / Supervisor			
								QC / QA Coordinator
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						
Other/Details:								

DART

AEROSPACE

Container No: S313018



Part: 648.3545

Job No: 215414

Serial No/Batch: S313018

Revision: REV.C

Inspector:

Exp Date:

Instructions:

Date: 11/16/20

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M301S11GA

PO / BATCH NO.: POHB047051

DATE: SEP 23 2020

S 302475

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 305P
 QUANTITY INSPECTED: 305P
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .125
 THICKNESS RECEIVED: .125
 SHEET SIZE ORDERED: 3' x 10'
 SHEET SIZE RECEIVED: 3' x 10'

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	AMS 5518 / ASTM A666
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	HIT 7592253
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: _____ DATE: SEP 23 2020	SIGNED OFF BY: _____ DATE: _____

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Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



O'Neal High-Performance Metals Group



Packing Slip

ORDER NO.: 03402278 FROM: CINC PAGE 1

CUST NUMBER: 1203820 NET WGT: 156.000 REQ. DATE: 09/21/20 CONFIRMED
SOLD TO: SHIP TO:
DART AEROSPACE LTD DART AEROSPACE LTD
1270 ABERDEEN ST 1270 ABERDEEN ST
HAWKESBURY ON HAWKESBURY ON
CANADA CN K6A 1K7 ONTARIO CANADA CN K6A 1K7

SALESPERSON: DONNA SMALLEY SHIP BY: 09/16/20
TERMS: NET 30 DAYS VIA: COMMON CARRIER
F.O.B.: SHIPPING POINT FREIGHT: PREPAID
CUST ORD NO.: POHB047051 RELEASE NO.:
RECEIVING PHONE:

LINE ITEM DESCRIPTION WIDTH LENGTH
0001 31548 301 1/2 HARD SHEET .125 36 120 IN

CLN#	ORD QTY	INVOICE QTY	SHIPPED QTY	WT	PCS
	30.000 SFT	30.000 SFT	156.000 LB	156.000	1

** 1 TEST REPORTS REQUIRED **

** 1 CERTS REQUIRED **

ECCN: 2B999.0 Export License: NLR Expiration Date: 0/00/00
PO: 49426595 HT: 7592253 PC: 1 CUSTOMER QTY: 30.000 UOM SFT
MLT: UNITED STATES MFG: UNITED STATES SLB/CL: ID# 72994103

BROKERS LIVINGSTON INTERNATIONAL

AREA	TYPE OF PKG	PKGS	GRS WEIGHT	WIDTH	LENGTH	HGHT
BAY 2	SKIDS	1.000	245.000	40.0000	124.0000	7
						CUBIC FT 20.0926

BY: LES
RT 000-

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UNLOAD TYPE: NONE SPECIFIED

RECEIVED

SEP 23 2020

DART AEROSPACE LTD.

DATE SHIPPED

1 PO:



POHB047051

DATE FILLED

THANK YOU FOR THIS ORDER

TERMS AND CONDITIONS APPLICABLE TO THE SALE OF THESE
PRODUCTS ARE SET FORTH ON OUR WEBSITE FOR YOUR CAREFUL
REVIEW.
<http://www.twmetals.com/invoice-terms.html>

United Performance Metals

Paul Isaacs
Paul Isaacs
Quality Associate

Customer Name: TW Metals - Exton
Customer PO: M49426595
UPM Sales Order: 755822
Date: 3/17/2020
Description/Form: STAINLESS 301 1/2 HARD - SHEET
Heat Number: 7592253 Ingot: 19L00356506

Width: 36.0000 Length: 120.0000
Size: .1250
Customer P/N:
Packing List Number: 143346-1
Quantity: 1092 LB 7 pc.

		AK Steel Corporation Metallurgical Test Report Coshocton Works 17400 State Route 16 Coshocton, OH 43812 U.S.A.		Page 1												
				Load No. 5391843 Sm No. 5391843												
C U S T O M E R	UNITED PERFORMANCE METALS INC 3475 SYMMES RD HAMILTON, OH 43015		S H I P T O	UNITED PERFORMANCE METALS O'NEAL PERFORMANCE METALS METAL PROCESSING DIVISION 3475 SYMMES ROAD HAMILTON, OH 43015												
				MILL ORDER NO. PROCESSOR ORDER NO. BUYERS ORDER NO. 271940-3395 CIN-35836-P14 CIN-35836-P14 PART NO. ENGLISH UNITS --PRODUCT-- METRIC UNITS .1250 NOM 36.0000 X 120.0000												
LIFTID	PIECE	HEAT	PARENT LIFTID	NET WEIGHT	OUTSIDE PROCESSOR ID											
729941-03-001	21	7592253	729941-03	3,285 LBS. 1,490 KG.	19L00356501											
729941-03-002	21	7592253	729941-03	3,260 LBS. 1,479 KG.	19L00356502											
729941-03-003	21	7592253	729941-03	3,275 LBS. 1,486 KG.	19L00356503											
729941-03-004	21	7592253	729941-03	3,270 LBS. 1,483 KG.	19L00356504											
729941-03-005	21	7592253	729941-03	3,275 LBS. 1,486 KG.	19L00356505											
729941-03-006	21	7592253	729941-03	3,275 LBS. 1,486 KG.	19L00356506											
729941-03-007	21	7592253	729941-03	3,275 LBS. 1,486 KG.	19L00356507											
729941-03-008	21	7592253	729941-03	3,260 LBS. 1,488 KG.	19L00356508											
729941-03-009	8	7592253	729941-03	1,250 LBS. 567 KG.	19L00356509											
TOTAL LIFTS	TOTAL PIECES			TOTAL NET WEIGHT												
9	176			27,445 LBS. 12,449 KG.												
L-Ladle Analysis of Heat P-Product Analysis of Parent Coil CHEMICAL ANALYSIS																
ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7592253	.10	1.11	.023	.001	.48	17.55	7.12	.19	.033	.24						
UPMACC Reviewed/Approved by OC Reviewed Specification(s): ALL Checked by: <i>Not Known</i> Pages 3 Date: 10/28/2019 TW METALS 49426595 MAR 18 2020 <i>JH</i> ACCEPTED BY																
*** CONTINUED ON NEXT PAGE ***																

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United Performance Metals

Paul Isaacs
Paul Isaacs
Quality Associate

Customer Name: TW Metals - Exton
Customer PO: M49426595
UPM Sales Order: 755822
Date: 3/17/2020
Description/Form: STAINLESS 301 1/2 HARD - SHEET
Heat Number: 7592253 Ingot: 19L00356506

Width: 36.0000 Length: 120.0000
Size: .1250
Customer P/N:
Packing List Number: 143346-1
Quantity: 1092 LB 7 pc.

		AK Steel Corporation Metallurgical Test Report Coshocton Works 17400 State Route 16 Coshocton, OH 43812 U.S.A.		Page 2
				Lead No. S391843 Srm No. S391843
C U S T O M E R	UNITED PERFORMANCE METALS INC 3475 SYMMES RD HAMILTON, OH 45015	S H I P T O	UNITED PERFORMANCE METALS O'NEAL PERFORMANCE METALS METAL PROCESSING DIVISION 3475 SYMMES ROAD HAMILTON, OH 45015	MILL ORDER NO. 271940-3395 PROCESSOR ORDER NO. CIN-35836-P14 BUYERS ORDER NO. CIN-35836-P14 PART NO. ENGLISH UNITS -PRODUCT- METRIC UNITS .1250 NOM 36.0000 X 120.0000

SHIPPING DATE: 10/25/2019

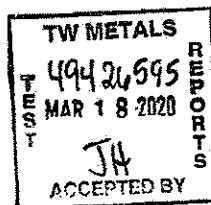
REMARKS THIS MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A. (DFARS 252.225.7001, 7008 & 7009 COMPLIANT).
NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.
COILED PRODUCTS CONTAIN NO WELDS
STEELMAKING PROCESS - EAF MELTED, AOD REFINED, CONTINUOUS CAST SLABS
STAINLESS STEELS SUPPLIED BY AK STEEL CORPORATION COMPLY WITH THE EUROPEAN END -OF-LIFE VEHICLE DIRECTIVE 2000/53/EC (ELVD) AND THE RESTRICTION OF HAZARDOUS SUBSTANCES DIRECTIVE KNOWN AS EU-DIRECTIVE 2011/65/EU, EFFECTIVE JANUARY 3, 2013 (ROHS 2)
RESIDUAL LEVELS OF Hg, Pb, Cd, & HEXAVALENT CHROMIUM ARE WITHIN ACCEPTABLE LIMITS ACCORDING TO THESE DIRECTIVES.
AK STEEL HAS IMPLEMENTED, OPERATES AND MAINTAINS A QUALITY MANAGEMENT SYSTEM IN ACCORDANCE WITH THE REQUIREMENTS OF THE PRESSURE EQUIPMENT DIRECTIVE (PED) 97/23/EC 7/2, ANNEX I, PARAGRAPH 4.3.
MATERIAL SUPPLIED IN ACCORDANCE WITH EN 10204:2004 TYPE 3.1
UPM-QRS-001 REV. B, EXCEPTIONS DATED AND APPROVED ON 02/22/2018.

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PRODUCT DESCRIPTION

CR SHT TYPE 301 STAINLESS NI 7.0% MIN TR FINISH 1/2 HARD SLIT EDGE * ASTM A 240-18 UNS S30100 CHEMISTRY ONLY * ASME SA-240 SECT I PART A 2017 EDITION CHEMISTRY ONLY * ASME SA-666 SECTION II PART A 2017 EDITION * ASTM F 899-12B (UNS S30100 TYPE 301) * AMS 5518M * ASTM A 666-15 * MIL-S-5059 D-AMEND-3 CANCELED * QQ-S-766-D (CANCELED) * UNS-S30100 13TH EDITION * UPM-301-1/2HD 06-04-08

PARENT LIFT	POS	DIR	COND	% ELONG	ELONG METHOD	ELONG GAUGE LENGTH	TENSILE STRENGTH (KSI)	Y.S. 2% OFFSET (KSI)	ROCKWELL HARDNESS Tail	ROCKWELL HARDNESS Front	
729941-03	T	T	A.S.T.M	193	MEASURED	2 Inch	167.6	130.4	C 36	C 35	



*** CONTINUED ON NEXT PAGE ***